

Work Order ID 44760

June 26, 2009 10:53:16 AM



Item ID: D3709-3

Accept



Setup Start



Revision ID: A

Stop



Item Name: Angle

Start Date: 15/07/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 03/08/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: MF

Date: 09/09/24 Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
----------	--------------

D3709	Rev A
-------	-------

100

0.00

Setup



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3709 ☐ Dwg Rev: ☐ Prog Rev: ☐

()

****grain direction on a 45 degree **** ☐ 2- Debur if necessary

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

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Page 2

Item ID: D3709-3

Accept

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Item Name: Angle

Start Date: 15/07/2009 Start Qty: 1.00

Required Date: 03/08/2009 Req'd Qty: 1.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:




SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130  Small Fab	Small Fab	0.00							
Small Fab	Memo	0.00							
Small Fab	Form as per dwg D3709								
140  QC	QC5- Inspect part completeness to step on W/O	0.00							
Quality Control	Memo	0.00							
150  HandFinish	Chemical Conversion Coat per QS1005 4.1	0.00							
• Hand Finishing	Memo	0.00							

W.D.U.W

Work Order ID 44760

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Page 3

Item ID: D3709-3

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Revision ID: A

Item Name: Angle

Start Date: 15/07/2009 Start Qty: 1.00

Required Date: 03/08/2009 Req'd Qty: 1.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:




SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160  QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00							
170  Packaging Packaging	Identify as per dwg & Stock Location: _____ Memo	0.00 0.00							
180  QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							

Picklist Print

June 26, 2009 10:53:15 AM

Page 1

Work Order ID: 44760



Parent Item: D3709-3RevA



Parent Item Name: Angle



Start Date: 15/07/2009

Required Date: 03/08/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6S.063		Purchased	No				sf	0.0000	0.2800			
												
6061-T6 .063 Sheet												

Date: Wednesday, 14/01/2009 3:23:33 PM
 User: Melanie Fauteux

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : ANGLE
 Job Number : 44760
 Estimate Number : 13640
 P.O. Number :
 This Issue : 14/01/2009 S.O. No. :
 Prsht Rev. : NC Part Number : D37093
 First Issue : / / Type : SMALL / MED FAB Drawing Number : D3709 PRELIM
 Previous Run : 05066 Drawing Revision : PRELIM
 Material :
 Due Date : 19/01/2009 Qty: 1 Um: Each
 Written By :
 Checked & Approved By : UMF 09-01-14
 Comment : Est Rev:A 08-10-31 new issue DD verified by:EC

Additional Product

PRELIMINARY ISSUE

Job Number:



09.01.14 PRE CAN \$09.502P

Seq. #: Machine Or Operation: Description:

1.0 M6061T6S063 6061-T6 .063 Sheet



Comment: Qty.: 0.2855 sf(s)/Unit Total: 0.2855 sf(s)

6061T6 aluminium sheet .063" thick

(M6061T6S063)

Batch: 108279 10551 1893-12

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D3709

Dwg Rev: PRE 1891-15

Prog Rev: 1891-15

****grain direction on a 45 degree ****

2- Deburr if necessary 1891-15 1893-12

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

ENGINEERING
APPROVAL

5.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: Form as per dwg D3709

SP 09/05/14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3709-3 PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: / Date: 05.11.24
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR: <u>44760</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
09/05/14	5	2 piece crack die to small change die radius .093, ∴ part dims. Rc: New design	<u>/</u> 05/11/22	Scrap & destroy Qty 3 Eng to re-design. No replace.	Mk 09/11/13	<u>/</u> 05/11/13	<u>/</u> 05/11/22	<u>/</u> 09-05-14

NOTE: Date & initial all entries

Date: Wednesday, 14/01/2009 3:23:33 PM
User: Melanie Fauteux

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ANGLE

Job Number: 44760

Part Number: D37093

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

Scrap

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

**ENGINEERING
APPROVAL**

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



POSITIVE RECALL

EFFECTIVE 01/01/09

AUTH [Signature]

RELEASED _____

DATE _____

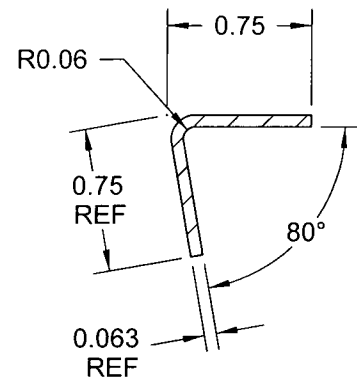
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

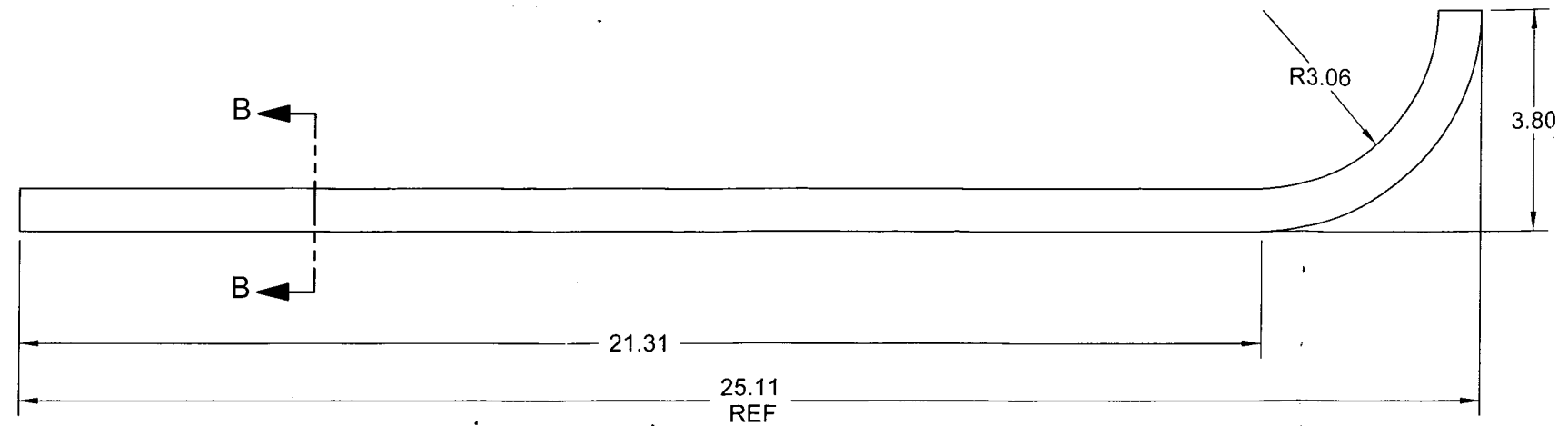
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

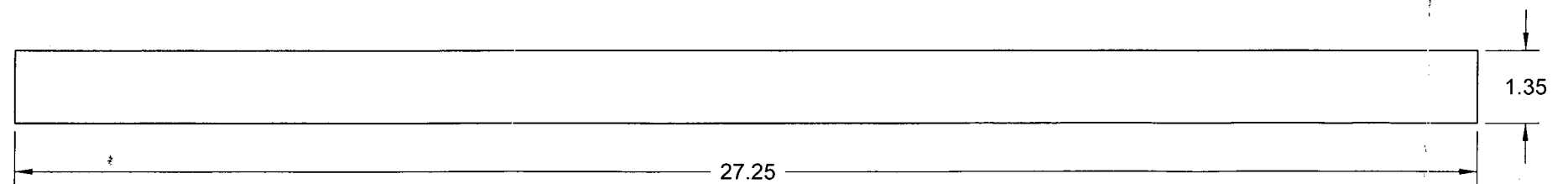
NOTE: Date & initial all entries



SECTION B-B
SCALE 2X



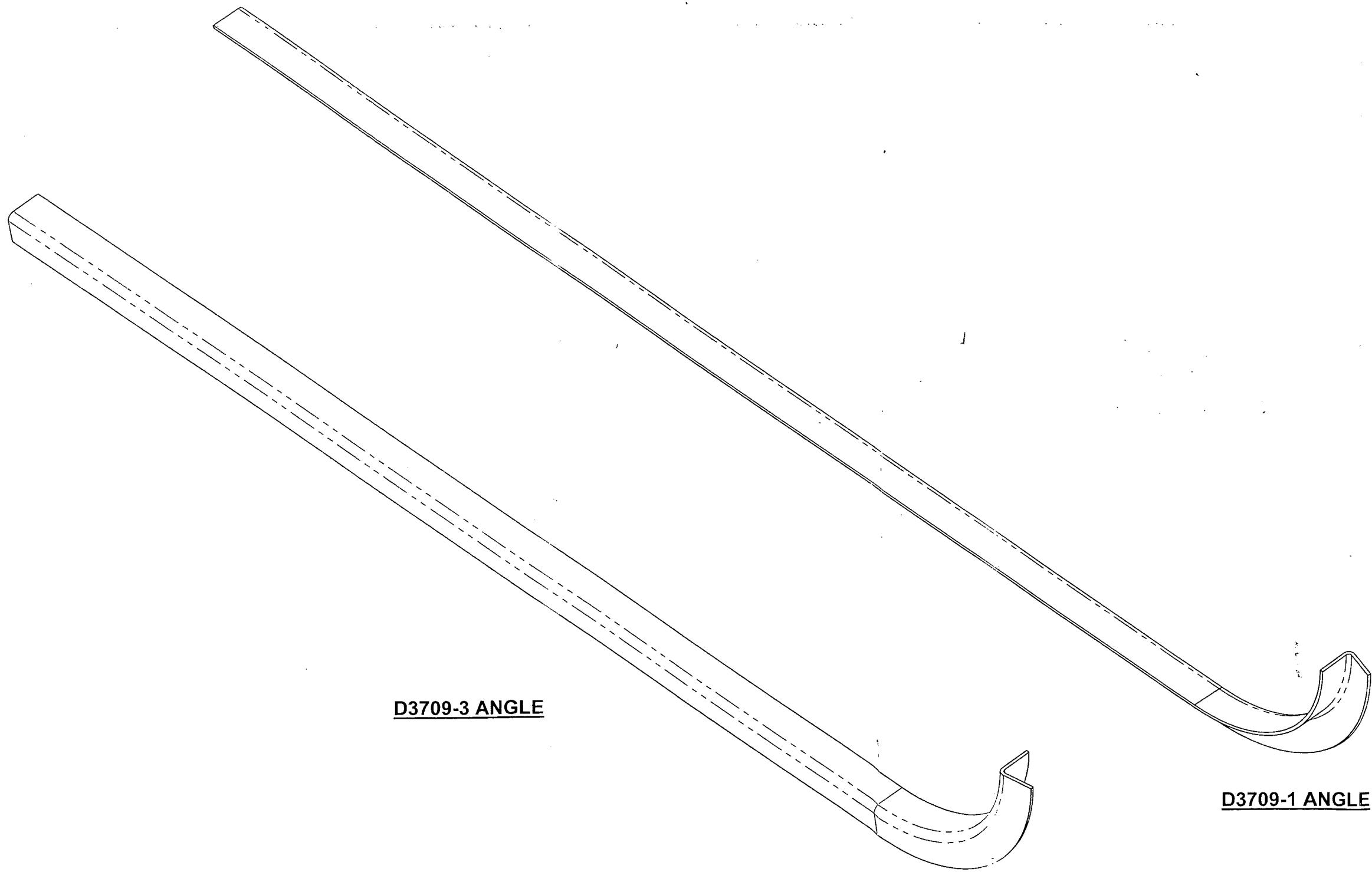
D3709-3 ANGLE
(MAKE FROM D3709-3F)



D3709-3F ANGLE FLAT PATTERN

PRELIMINARY ISSUE
09.01.14 per
ECN

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3709	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		ANGLE	NTS
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D3709-3 ANGLE

D3709-1 ANGLE

PRELIMINARY ISSUE

per 08.05.02
per 08.05.02

- NOTES:**
- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.063 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
(REF. DART SPEC. M6061T6S.063)
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3709-X" USING FINE POINT PERMANENT INK MARKER
 - 7) WEIGHT: D3709-1 = 0.48 lbs
D3709-3 = 0.16 lbs

A	NEW ISSUE		MB	08.05.02
REV.	DESCRIPTION		BY	DATE
DESIGN		DART AEROSPACE LTD HAV/KESBURY, ONTARIO, CANADA		
DRAWN				
CHECKED		DRAWING NO.	REV. A	
MFG. APPR.		D3709	SHEET 1 OF 3	
APPROVED		TITLE	SCALE	
DE APPR.		ANGLE	NTS	
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